



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5000442

D3913-041
Job Sheet 166549



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/23/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/20/17	0.00	0.00	Start up container	2017-10-28
100	Large Fab	1 pcs	10/21/17	0.00	10.00	Large Fab 1	2017-10-25
110	QC	1 pcs	10/21/17	0.00	0.00	QC9	2017-10-25
120	QC	1 pcs	10/21/17	0.00	0.00	QC5	38
125	HandFinish	1 pcs	10/21/17	0.00	0.29	HandFinish2	BR 17-11-9
130	Powdercoat	1 pcs	10/21/17	0.00	0.93	Powdercoat2	BR 17-11-9
140	QC	1 pcs	10/21/17	0.00	0.00	QC3	12/11/13
150	HandFinish	1 pcs	10/23/17	0.00	0.50	HandFinish4	12/14/13
160	QC	1 pcs	10/23/17	0.00	0.00	QC5	38
170	Packaging	1 pcs	10/23/17	0.00	0.00	Packaging3	OCT 14 2017
180	QC21-SA	1 Ea	10/23/17	0.00	0.00	QC21	21 NOV 14 2017

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

150 - Pick Kit

M 1300H START: 1:30 O.V.T. 3:30 FINISH: 1:45

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	32	0	0
	D3913-1	1	2	0	0
	D3913-15	1	13	0	0
	D3913-3	1	4	0	0
	D3913-7	2	4	0	0
	D3913-9	1	1	0	0
	D3916-041	2	6	0	0
	D3916-5	3	7	0	0
	D4016-1	3	16	0	0
	D4017-7	3	24	0	0
	D4017-9	2	6	0	0
	D4020-11	2	0	0	0
	D4021-1	3	36	0	0
	D4021-5	2	20	0	0
	D4034-041	1	3	0	0

500548x1

16615241

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QS1042) Approval _____

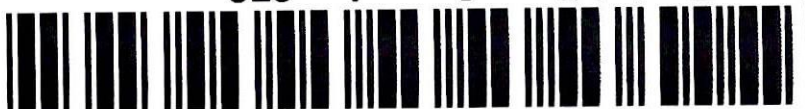
Descript _____

Job No: 166549
Mfg Date: 10/12/17

Packaging

Change No:
Operation:
Revision:
PART NO: D3913-041

Long Basket Base Assembly, 350



Root Cause

Environment ☐	No Re-ve ☐	DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	ss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐		gram ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Si ☐			Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐			Part Incorrect ☐
Handling/Pre ☐	Training ☐		ck Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐			Part Moved ☐
Internal Transport ☐	Poor Information ☐		Cutts ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐		Crushing ☐	Finish ☐
LOA ☐	Product Improvement ☐		Heat Treat ☐	Misread ☐
Substation ☐	Process Improvement ☐		Wave/Twist in Tube ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	Cut Too Short ☐		
Misidentified ☐	Past Due ☐	Instructions Incomplete/Unclear ☐		
		Drill Holes ☐		
		Out of Sequence ☐		
		Off-set ☐		
		Mislabeled ☐		
		Fit/Function ☐		
		Misaligned/off center ☐		

OTHER : _____

150-HandFinish

D4034-043

D4672-1

M304EX0.75-16F

AN3-10A

D2931 5008921

MS20600-AD4W3 5008921

MS21042L3 5008922

NAS1149F0332P 5008923

12
6
2
2
6
33
2
1

1,231
462
99
1,336
38
0
9
3

0
0
0
0
0
0
0
0

0
0
0
0
0
0
0
0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								